

Date: Thursday, 2/14/2008 11:01:31 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PANEL
 Job Number : 37441
 Estimate Number : 10905
 P.O. Number :
 This Issue : 2/14/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 35486
 Part Number : D33302
 Drawing Number : D3330 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 3/15/2008 Qty: 6 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. A 05.01.13 New issue KJ/JLM
 Est Rev:B Now on Waterjet 06-09-25 JLM
 est C 07.05.14 rev C dwg EC
 Est D 07.12.12 Rev D dwg EC verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S125 1010-1025 sheet .125



Comment: Qty.: 1.1445 sf(s)/Unit Total : 6.8670 sf(s)

1010-1025 sheet .125

Batch: 106140 HB 8-2-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3330

Dwg Rev: D HB 8-2-22

Prog Rev: D

2-Deburr if necessary HB 8-2-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D3330

HB 08/03/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 11:01:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 37441

Part Number: D33302

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/12 (46)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 488

AS

08/03/12 (46)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/12

Job Completion



mi 2008/3/12

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

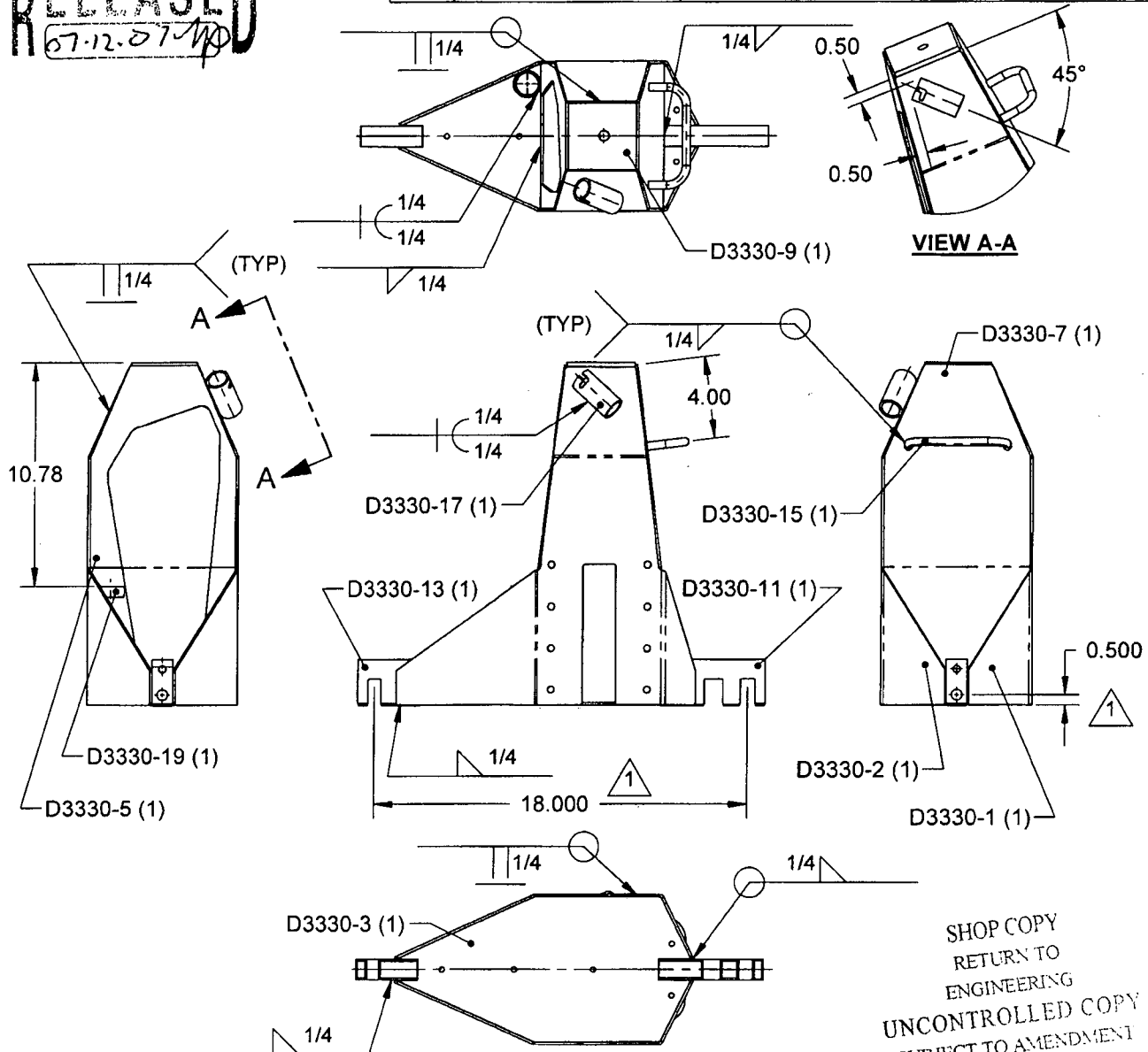
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>JB</i>	APPROVED <i>WJ</i>	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

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07.12.07



D3330-041 FRAME WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

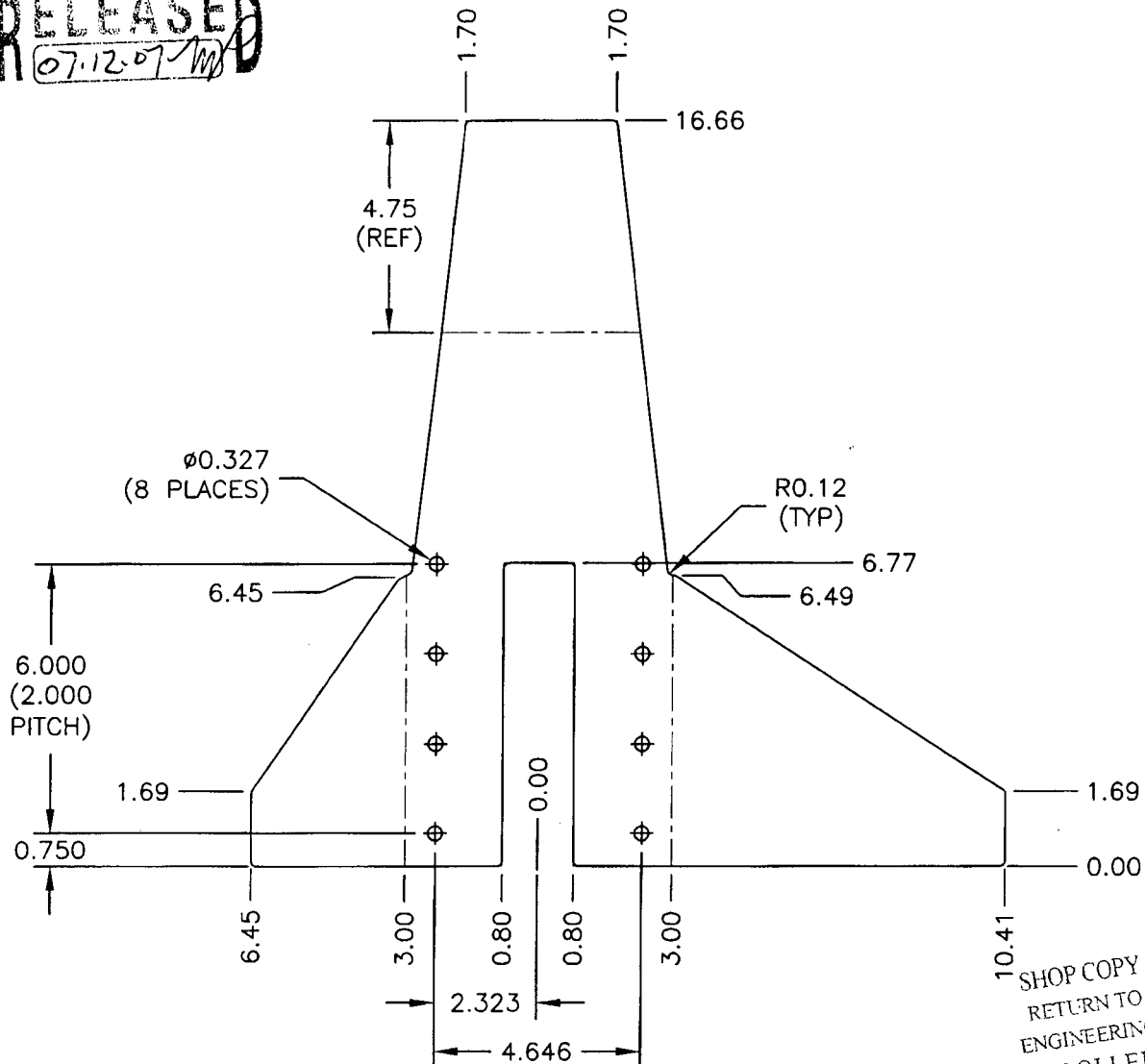
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07.12.07 *[Signature]***D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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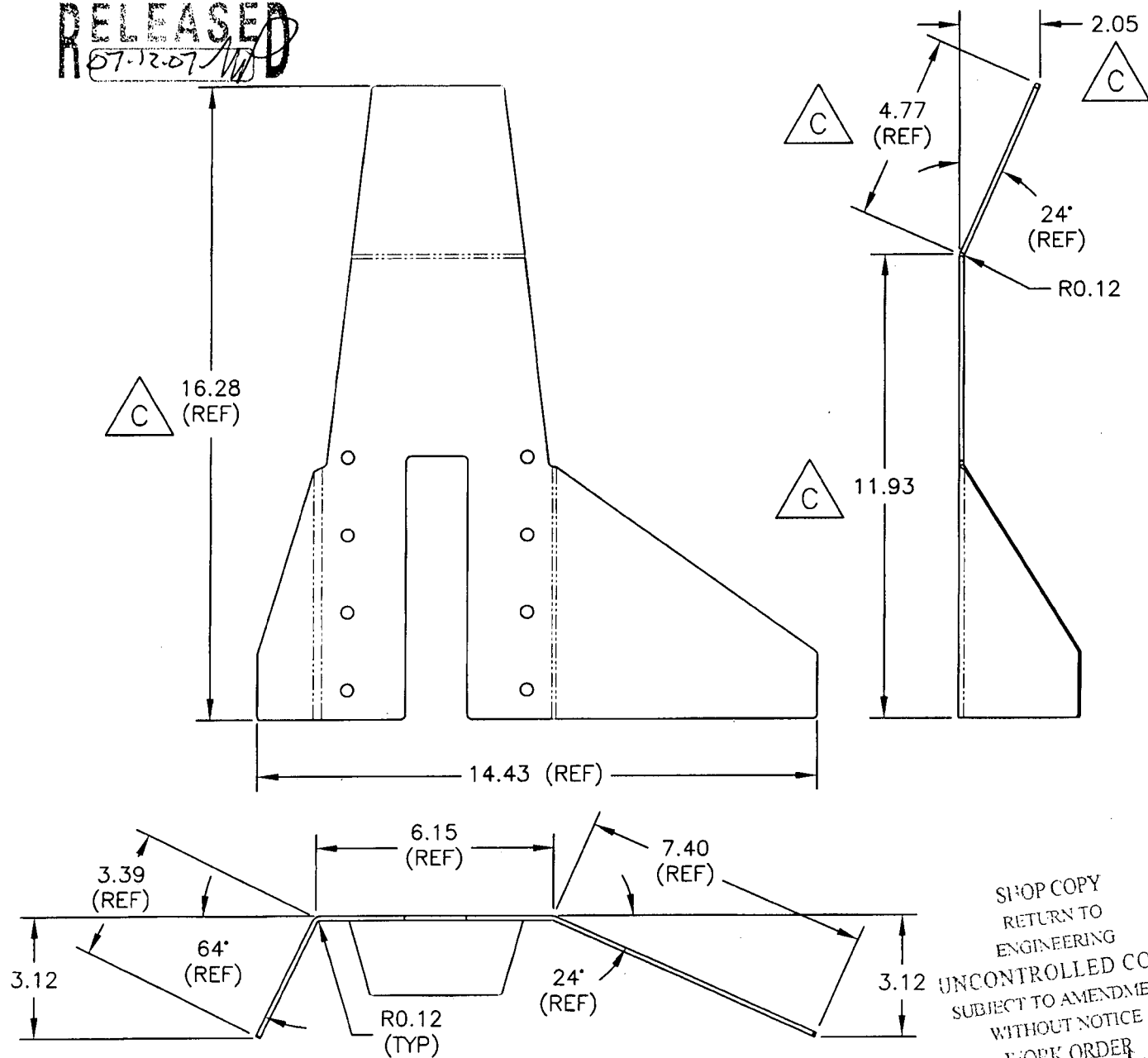
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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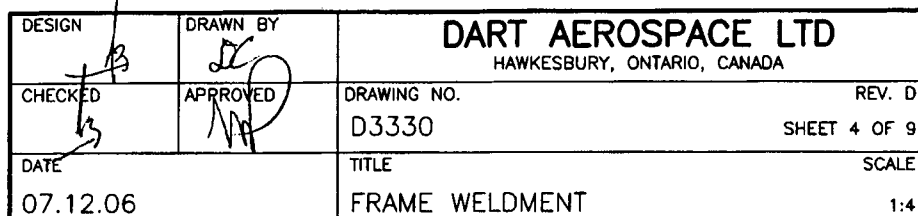


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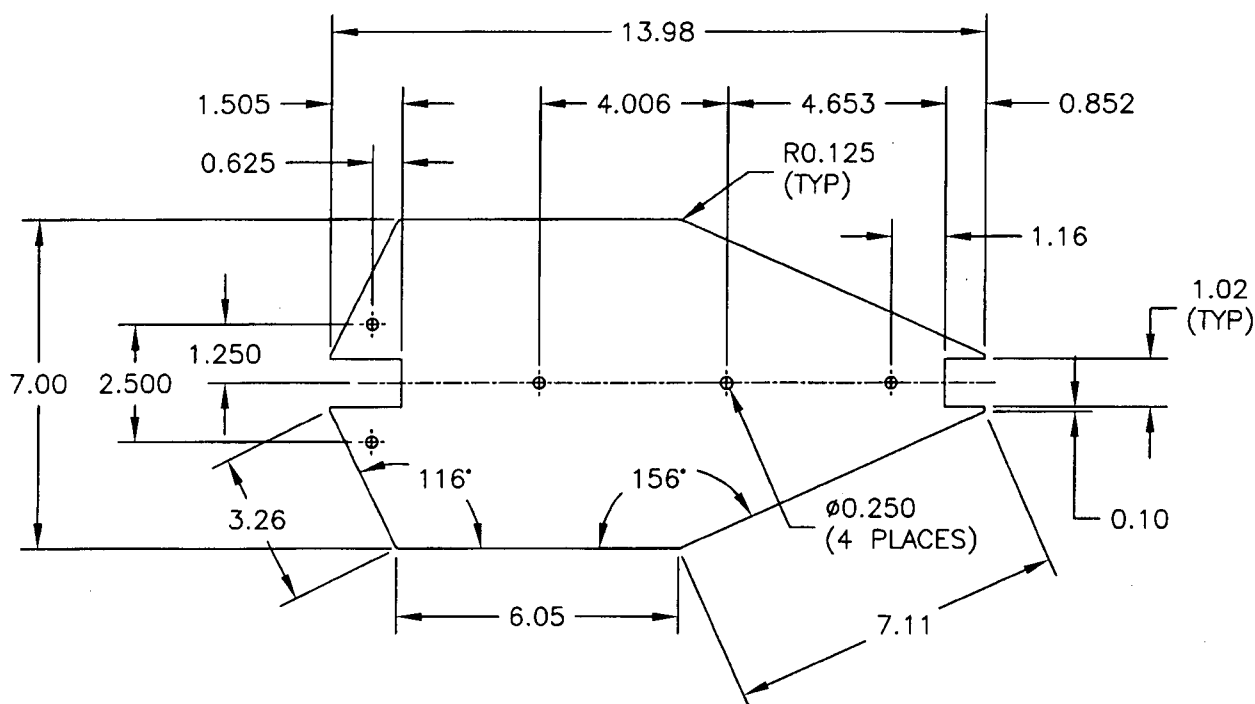
D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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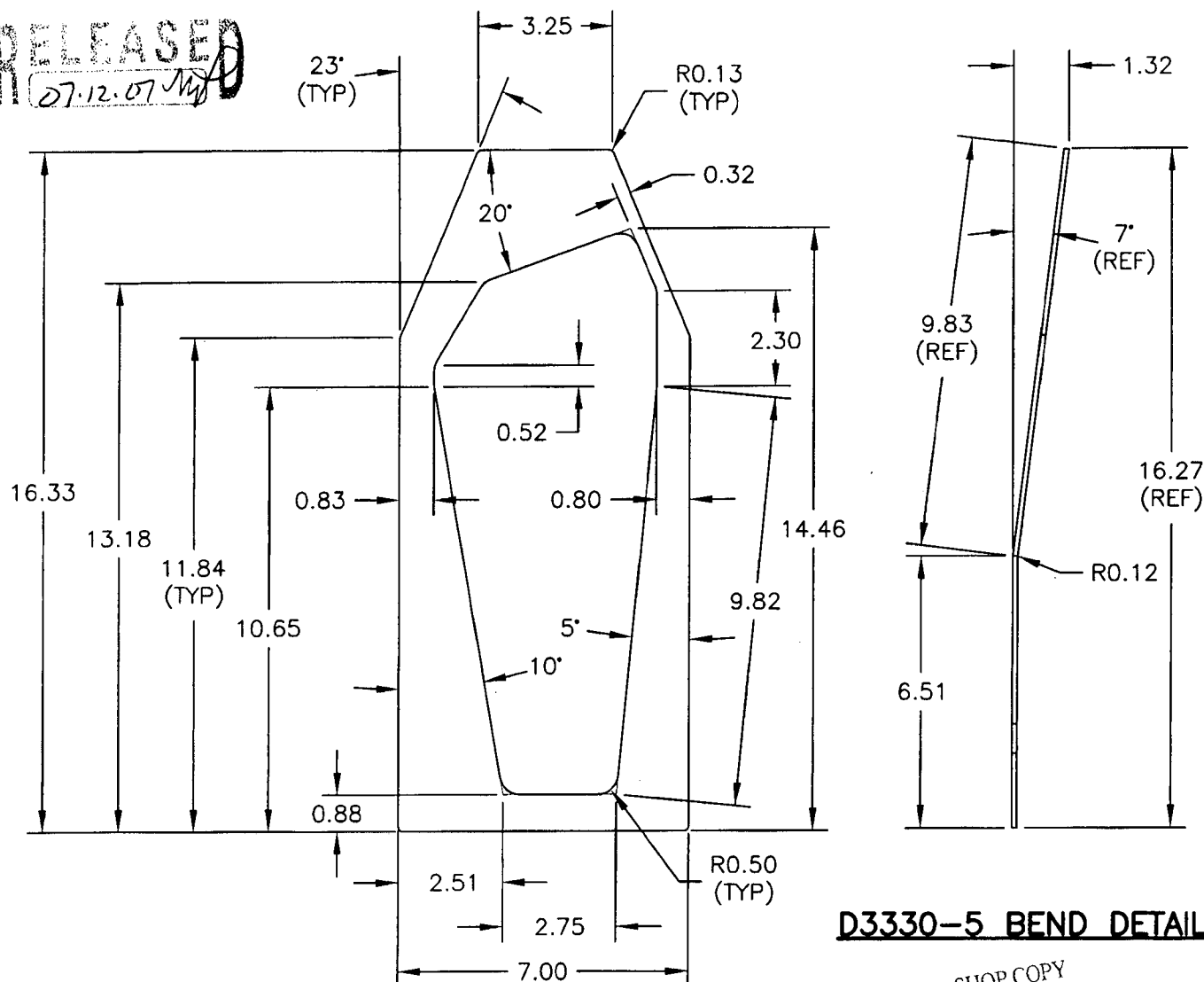
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:4

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**FLAT PATTERN****D3330-5 BEND DETAIL**

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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

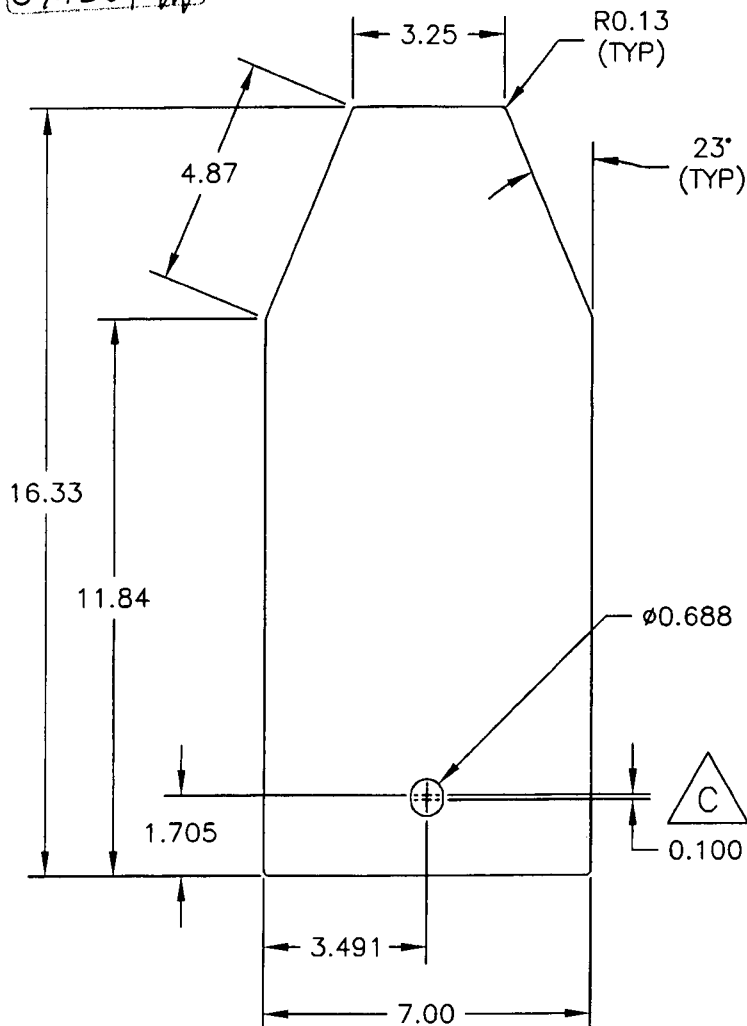
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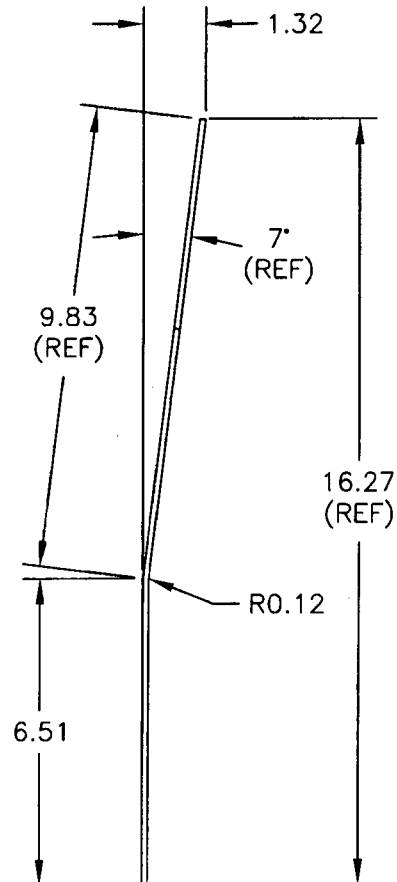
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DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

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FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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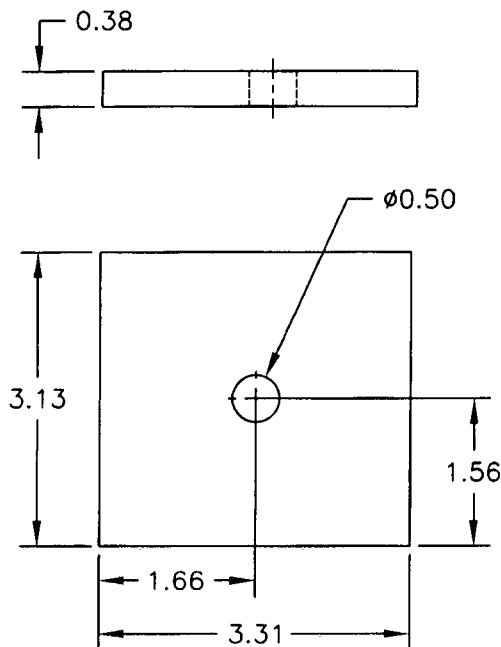
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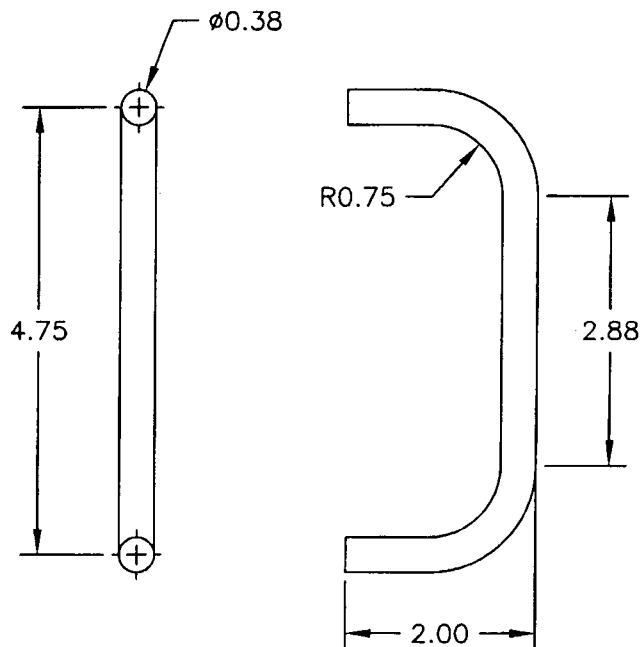


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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

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1 D3330-9 TOP PLATE



2 D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL (REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097 (REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

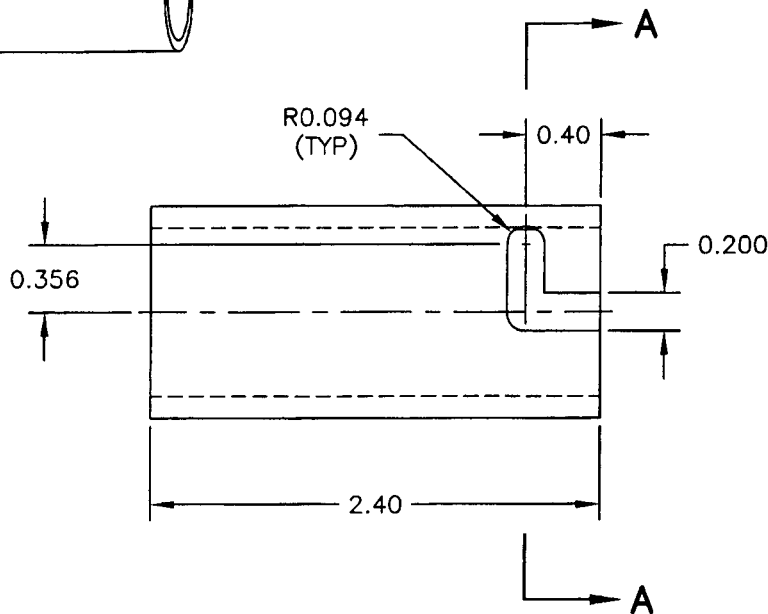
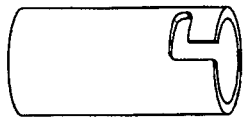
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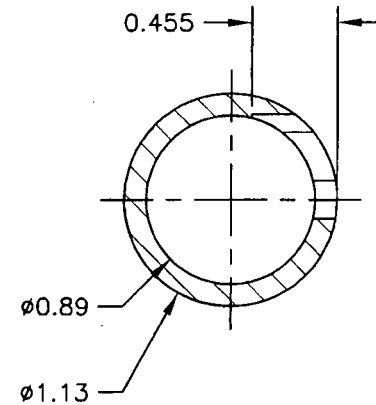
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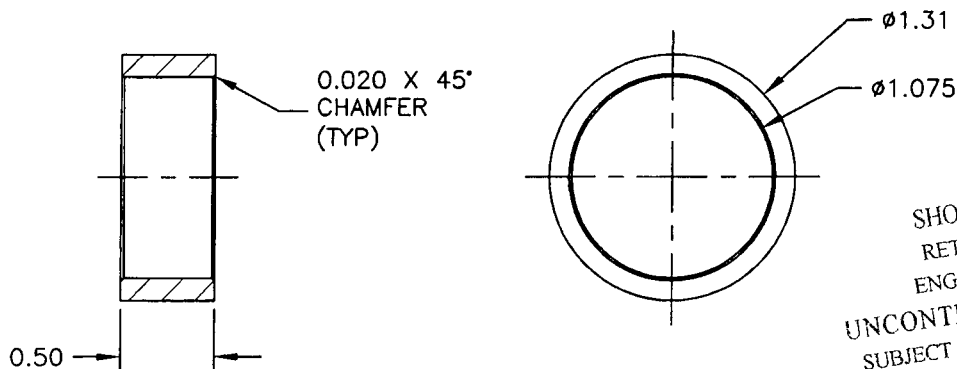


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SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

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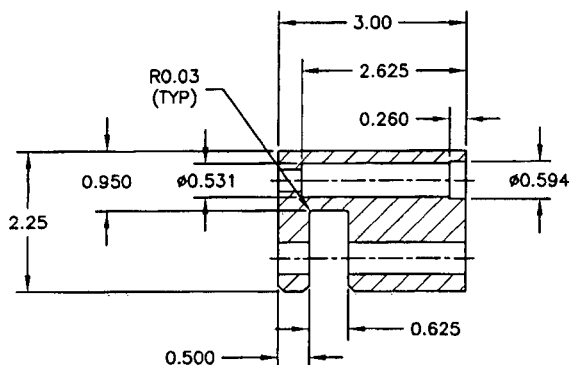
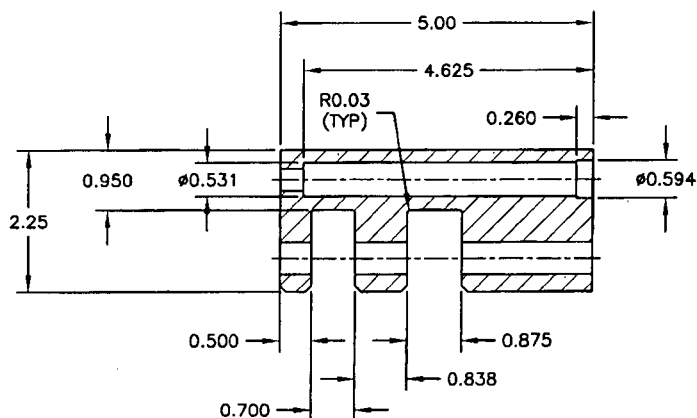
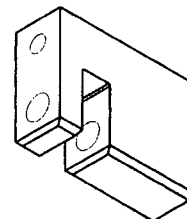
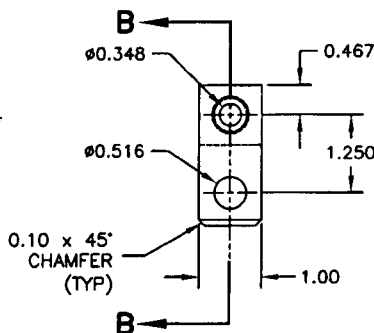
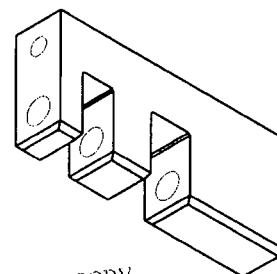
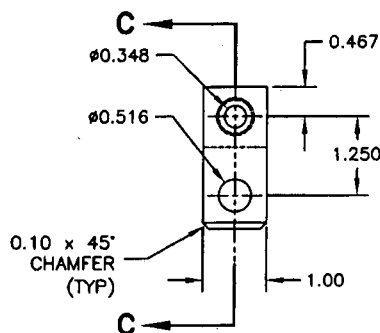
- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

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07.12.07 *[Signature]***SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET**

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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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